

OK IF FOR STOCK
CP 16/4/25

Work Order ID 144791

Monday, April 25, 2016 10:04:02 AM

144791

Page 1

Item ID: D412-698-023

Accept

N900040100

Setup

Start

NS1

Revision ID: URF 16-531

Item Name: Automatic Door Opener (fits LH or RH)

Stop

NS2

Start Date: 4/25/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/2/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: ML5 Date: APR 25 2016

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E U/R								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-698-023		CHG002						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.24							
Quality Control									

U/R

ML5 1604-28

8x

DAS
6
9-89

APR 27 2016

8x

DAS
6
9-89

APR 27 2016

8x

DAS
20
9-89

APR 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 144791

Monday, April 25, 2016 10:04:02 AM

144791

Page 2

Item ID: D412-698-023

Accept

N900040100

Setup Start

NS1

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Item Name: Automatic Door Opener (fits LH or RH)

Stop

NS2

Start Date: 4/25/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/2/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00				8x	DAS 28 3.80		APR 27 2016
Packaging	Identify and pack for shipping as per PPP D412-698-023 Location:FG022								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.80							
Quality Control									

MCS APR 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, April 25, 2016 10:04:05 AM

Page 1

Work Order ID: 144791

144791

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 4/25/2016

Required Date: 5/2/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-11 *D3552-11* Door Prop		Manufactured	No			120	Each	22.0000	1	8		DAS 6 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
	DAS 28 9-89			FG				4				27 3-39	
				128491				2					
				80345				2					
				ST363				18					
				141994				6		6			
				142260				12		2			
D3594-043 *D3594-043* Floor Doubler Assembly, LH		Manufactured	No			120	Each	18.0000	1	8		DAS 6 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
	DAS 28 9-89			ST504				18				27 9-89	
				130499				18					
D3594-044 *D3594-044* Floor Doubler Assembly, RH		Manufactured	No			120	Each	22.0000	1	8		DAS 6 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
	DAS 28 9-89			ST504				22				27 9-89	
				130500				22					

APR 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐		No Re-verification		Pressure/Forced		Temperature/Cure		Power Loss/Surge		Positioned Wrong
Design	☐		Operator		Bending		Set-up		Folio/Program		Outside Dimensions
Doc/Data	☐		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance
Equip/Tooling	☐		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect
Handling/Pre	☐		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing
Material	☐		Use for Testing		Cuffs		Contamination		Out of Sequence		Part Moved
Internal Transport	☐		Poor Information		Crushing		Countersink		Off-set		Drawing
Tribal Knowledge	☐		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish
LOA	☐		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread
Substation	☐		Process Improvement		Marks/Chatter		Drill Holes		Misaligned/off center		Turning Sequence
Past Expiry Date	☐		Manufacturing Process		OTHER :						
Misidentified	☐		Past Due								

Picklist Print

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Page 2

Work Order ID: 144791

144791

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 4/25/2016

Required Date: 5/2/2016

Start Qty: 8.00

Required Qty: 8.00

D3594-5 Manufactured No

120

Each

12.0000

1

8

D3594-5

Doubler

DAS
28
9-89

**

DAS

8

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST044

12

130501

12

D3622-1

Manufactured No

120

Each

28.0000

2

16

D3622-1

Ball Stud

**

DAS

8

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST046

8

131523

8

ST051A

20

131624

20

MS20426AD4-4

Purchased No

120

Each

4,795.000

2

16

MS20426AD4-4

Rivet

DAS
28
9-89

**

DAS

8

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

GA

2102

125445

2102

ST312

2693

m132536

2693

MS21073L5

Purchased No

120

Each

28.0000

1

8

MS21073L5

Anchor Nut

DAS
28
9-89

**

DAS

8

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST298

28

m131187

3

m132680

22

m132734

3

APR 27 2016

Monday, April 25, 2016 10:04:06 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, April 25, 2016 10:04:06 AM

Page 3

Work Order ID: 144791

144791

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener (fits LH or RH)

Start Date: 4/25/2016

Required Date: 5/2/2016

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0516J

Purchased

No

120

Each

175.0000

2

16

NAS1149D0516.J

Washer

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST264

175

M129706

175

DAS
28
9-89

16

APR 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 144791

Monday, April 25, 2016 10:04:02 AM

144791

Page 1

Item ID: D412-698-023

Accept

N9000040100

Setup Start

NS1

Revision ID: URF 16-531

Item Name: Automatic Door Opener (fits LH or RH)

Stop

NS2

Start Date: 4/25/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/2/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLS Date: APR 25 2016

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E U/R								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-698-023		CHG002						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.24							
Quality Control									

MLS APR 26 2016



DAS
28
9-89

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E
Date: 08.05.01